

Work Order ID 51159

August 5, 2009 7:48:29 AM

Item ID: D3041-1

Revision ID: C-1

Item Name: Clamp

Start Date: 8/05/09

Start Qty: 30.00

Required Date: 8/10/09

Req'd Qty: 20.00

Split 26

Accept



Setup Start



Stop



Reference:

Approvals: Process Plan:

W

Date:

Tooling:

Date:

Run Start



Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3041

Rev C

100



Bandsaw

BAND SAW

0.00

30 0

DD 07/08/05

110



HAAS CNC VERTICAL MACHINING #1

HAAS I

HAAS CNC vertical machine #1

Memo

Machine per folio FA153

0.00

30 0

DD 07/08/06

120



QC2- Inspect parts off machine FAI/FAIB

QC

Quality Control

Memo

0.00

DD 07/08/06

30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 51159

August 5, 2009 7:48:29 AM



Page 2

Item ID: D3041-1

Accept



Setup Start



Revision ID: C-1

Stop



Item Name: Clamp

Start Date: 8/05/09 Start Qty: 30.00



Cust Item ID:

Required Date: 8/10/09 Req'd Qty: 30.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130



QC

Quality Control

QC8- Inspect parts - second check

0.00

88 09/08/10

140



HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00

=> 09-08-10

(X30)

el

150



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

0.00

>> 09/08/10

(X30) counter

q

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC8- Inspect parts - second check	0.00	88 09/08/10						
140	Chemical Conversion Coat per QSI005 4.1	0.00		=> 09-08-10	(X30)				el
150	QC5- Inspect part completeness to step on W/O	0.00		>> 09/08/10	(X30)				counter

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 51159

August 5, 2009 7:48:29 AM



Page 3

Item ID: D3041-1

Accept



Setup

Start



Revision ID: C-1

Stop



Item Name: Clamp

Start Date: 8/05/09 Start Qty: 30.00



Cust Item ID:

Required Date: 8/10/09 Req'd Qty: 30.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

160



Powdercoat

Operation
Description

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

Set Up/
Run Hours

0.00

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

170



QC

Quality Control

Memo QC3- Inspect Part Finish

0.00

0.00

⇒ Sarlolo

counter

(X30)

φ

180



Small Fab

Small Fab

0.00

Memo

0.00

1- Press D2611 bearing into lug as per Dwg D3041-2- Stake bearing into place
as per Dwg D3041-2-**PLEASE SEE JASON BEFORE PRESSING**
BEARINGS FOR NEW TOOLING**

RE

8/09/09/31 26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 51159

August 5, 2009 7:48:29 AM



Page 4

Item ID: D3041-1

Accept



Setup Start



Revision ID: C-1

Stop



Item Name: Clamp

Start Date: 8/05/09 Start Qty: 30.00



Cust Item ID:

Required Date: 8/10/09 Req'd Qty: 30.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC5- Inspect part completeness to step on W/O

0.00

27/08/31

Counted
X26

QC

Memo

0.00

Quality Control

200

Identify as per dwg & Stock Location: 463

0.00

Peggy (26)

Packaging

Memo

0.00

Packaging

210

QC21- Final Inspection - Work Order Release

0.00

09/09/08 JJ

QC

Memo

0.00

Quality Control

MF 09-09-08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Picklist Print

August 5, 2009 7:48:29 AM

Page 1

Work Order ID: 51159



Parent Item: D3041-1RevC-1



Parent Item Name: Clamp

Start Date: 8/05/09

Required Date: 8/10/09

Comments:

Start Qty: 30.00

Required Qty: 30.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2423RevB1		Manufactured	No			180	f	760.9447	2.6305			

Lug Extrusion

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST	760.94468
43722	213.01468
44529	22.39
45800	525.54

D2611RevC



Bearing

Manufactured	No	100	Each	37.0000	30.0000
--------------	----	-----	------	---------	---------

3125(f) DJ 09/08/05

EP 09/08/31

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST	37
46841	8
50521	29

B Side 2

2e

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	51159
Description: CLAMP	Part Number:	D3041-1
Inspection Dwg: D3041 Rev: C		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

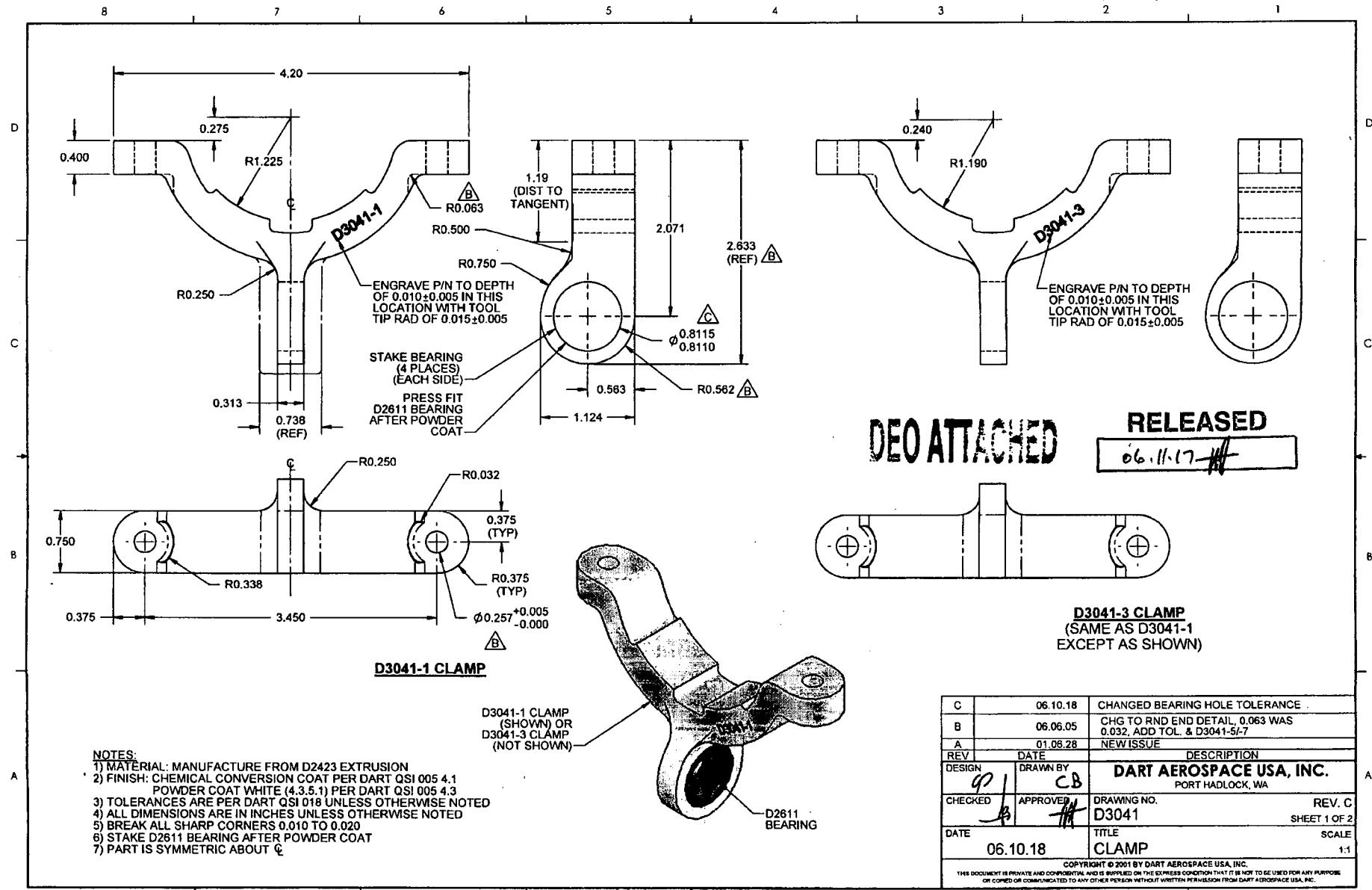
First Article Prototype

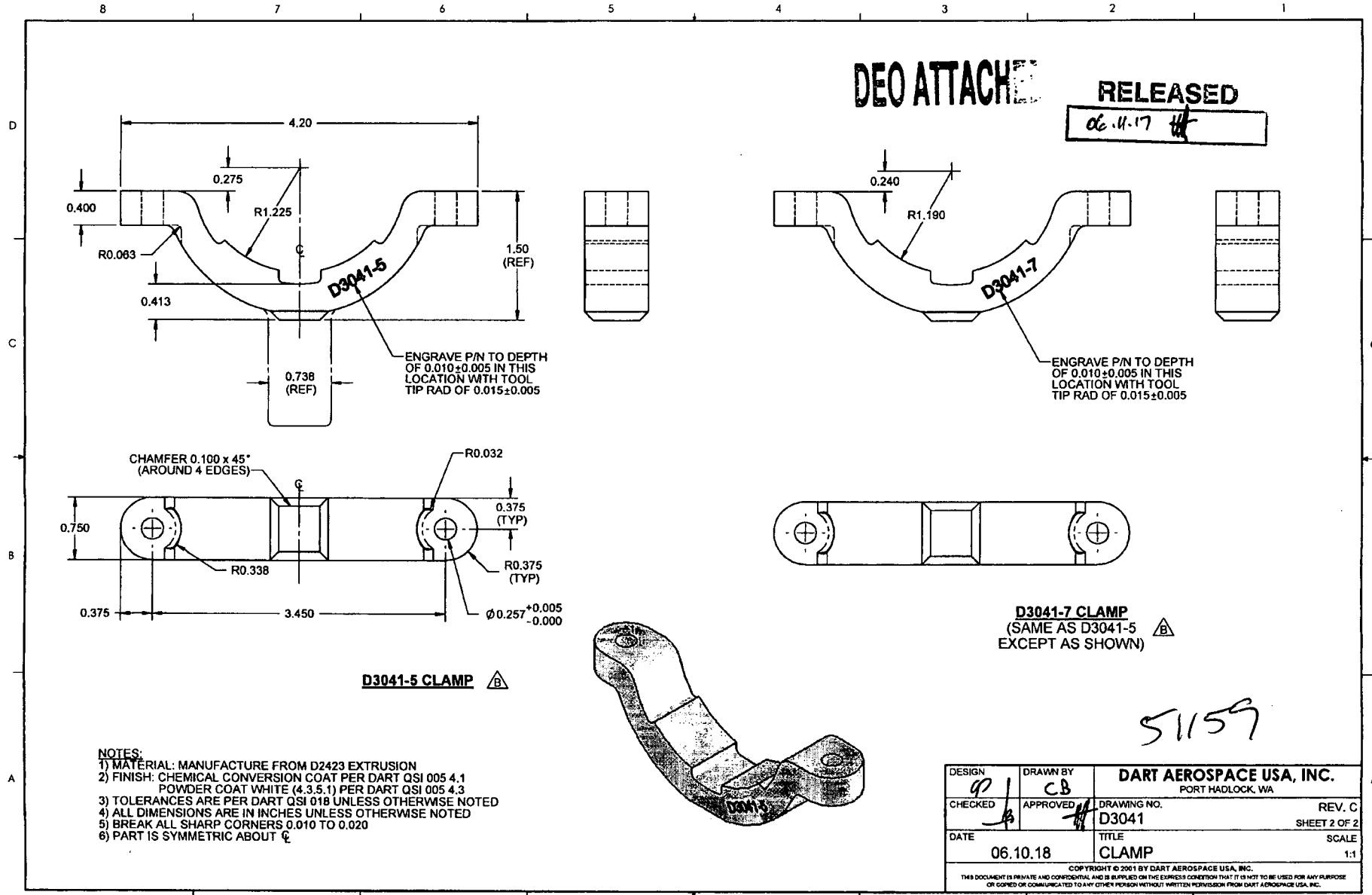
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
4.20	± 0.030	4.203	✓			
0.275	± 0.010	0.275	✓			
0.400	± 0.010	0.393	✓			
R1.225	± 0.010	1.225	✓			
R0.250	± 0.010	0.250	✓			
0.313	± 0.010	0.310	✓			
R0.063	± 0.010	0.063	✓			
R0.500	± 0.010	0.500	✓			
R0.750	± 0.010	0.750	✓			
1.124	± 0.010	1.128	✓			
0.563	± 0.010	0.567	✓			
R0.562	± 0.010	0.562	✓			
$\phi 0.811$	$+0.005/-0.0000$	0.811	✓			
2.633	± 0.010	2.6345	✓			(REF)
2.071	± 0.010	2.073	✓			
0.750	± 0.010	0.753	✓			
0.375	± 0.010	0.377	✓			(TYP)
3.450	± 0.010	3.447	✓			
$\phi 0.257$	$+0.006/-0.001$	0.258	✓			
R0.375	± 0.010	0.375	✓			(TYP)
R0.032	± 0.010	0.032	✓			
R0.250	± 0.010	0.250	✓			

Measured by:		Audited by:		Prototype Approval:	N/A
Date:	09/08/10	Date:	09/08/10	Date:	N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

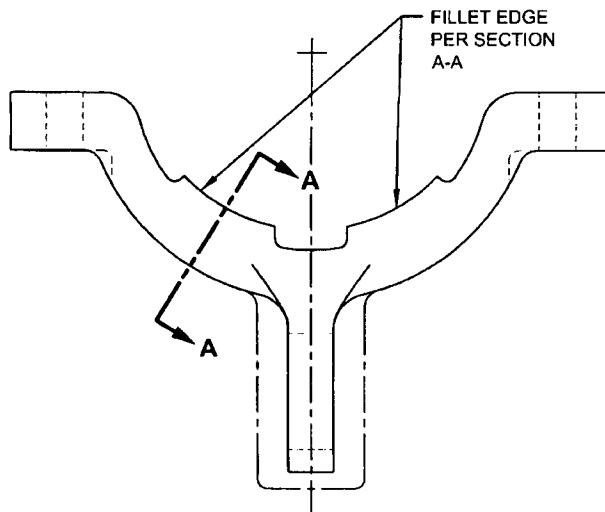
MOS1159





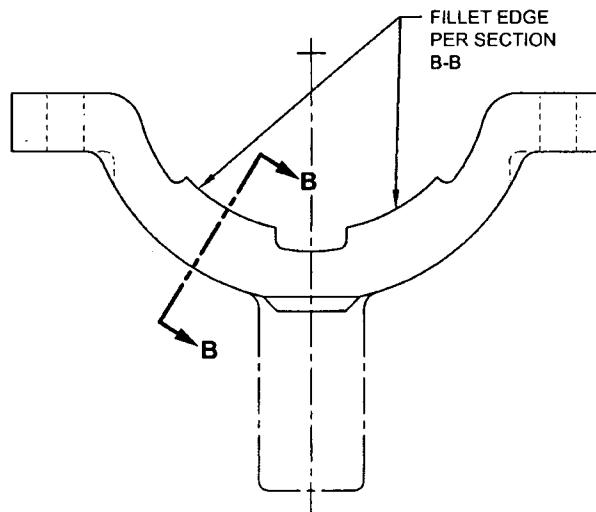
DRAWING NO. D3041	TITLE CLAMP	REV. C	DART AEROSPACE LTD ENGINEERING ORDER	D.E.O. NO. D3041-C-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN <i>AJS</i>	CHECKED		MFG. APPR. <i>[Signature]</i>	APPROVED <i>JMD</i>	DE APPR. <i>[Signature]</i>	
DATE 09.03.04	DATE 09.03.12	DATE 09.03.12	DATE 09.03.13	DATE 09.03.13	DATE 09.03.13	

ADD FILLETS TO -1/-3/-5/-7 PER SECTIONS A-A AND B-B TO PREVENT CHAFING OF RUBBER CUSHIONS AS SHOWN:



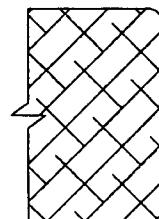
D3041-1 CLAMP

D3041-3 CLAMP



D3041-5 CLAMP

D3041-7 CLAMP



R0.060 MIN - R0.10 MAX
2PL

SECTION A-A

SCALE 2X

SECTION B-B

SCALE 2X

RELEASED
09/07/07 MJD

51159

SEE PAR 122 FOR FURTHER DETAILS

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